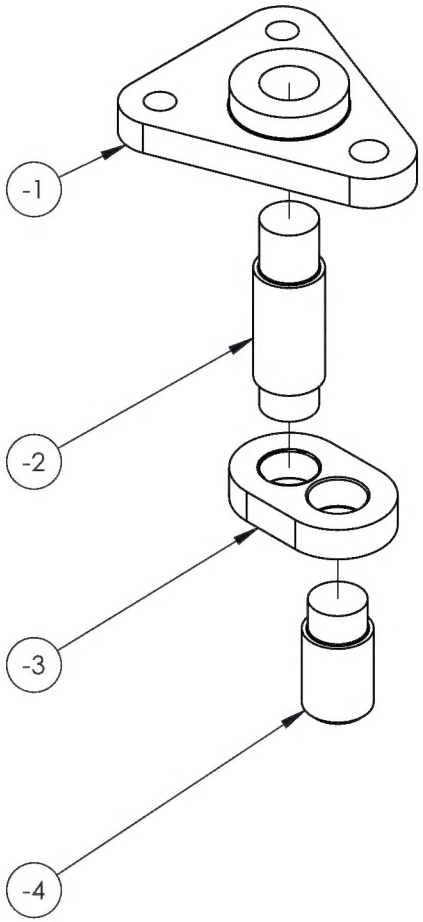
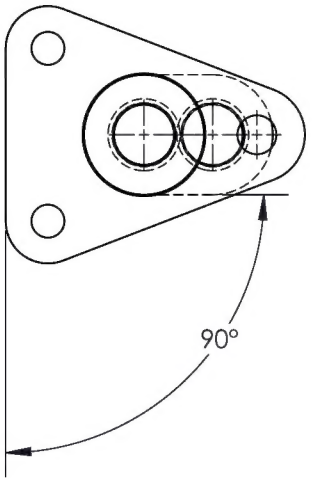
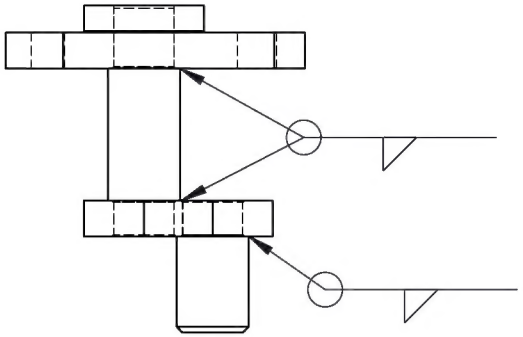
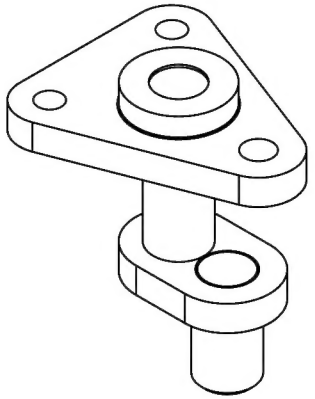
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATED TO NEW DRAFTING STANDARDS. ADDED MATERIAL OPTION 4140 Q&T/4142 Q&T TO **-1**, **-4**. ADDED MATERIAL OPTION 1018/1020 TO **-3**, **-4**.	7/27/2015	SM	JAG
3	16-0269	UPDATED TO NEW STANDARDS. ADDED DIM 90°. **-1** ADDED ENGRAVE NOTE; CH'D DIM WAS Ø.625 IS Ø.626/.625, WAS 1.000 IS 2X 1.000. **-2** CH'D DIM WAS Ø.625 SLIP FIT WITH -1 IS Ø.6238/.6231 (S.F. -1), WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR. **-3** CH'D DIM WAS Ø.625 SLIP FIT WITH -2 IS Ø.626/.625 (S.F. -2), WAS Ø.625 SLIP FIT WITH -4 IS Ø.626/.625 (S.F. -4); CH'D MATERIAL WAS A36 IS A36/1018/1020 HR. **-4** CH'D DIM WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 4140 Q&T/4142 Q&T IS 4140/4142; ADDED HEAT TREAT.	12/6/2016	SM	JAG









NOTE:
1. ZINC PLATE, ASTM B633 TYPE I SC 2, AFTER WELDING

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	4140/4142		2
			-2	1	MID POST	1018/1020 CR		3
			-3	1	CENTER PLATE	A36/1018/1020 HR		4
			-4	1	END POST	4140/4142		5

DART AEROSPACE

TITLE: ADAPTER-TURNOVER STAND

DWG NO. RB6798316 REV. 3

MAT'L

HEAT TREAT

FINISH SEE NOTE 1

SPEC

DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

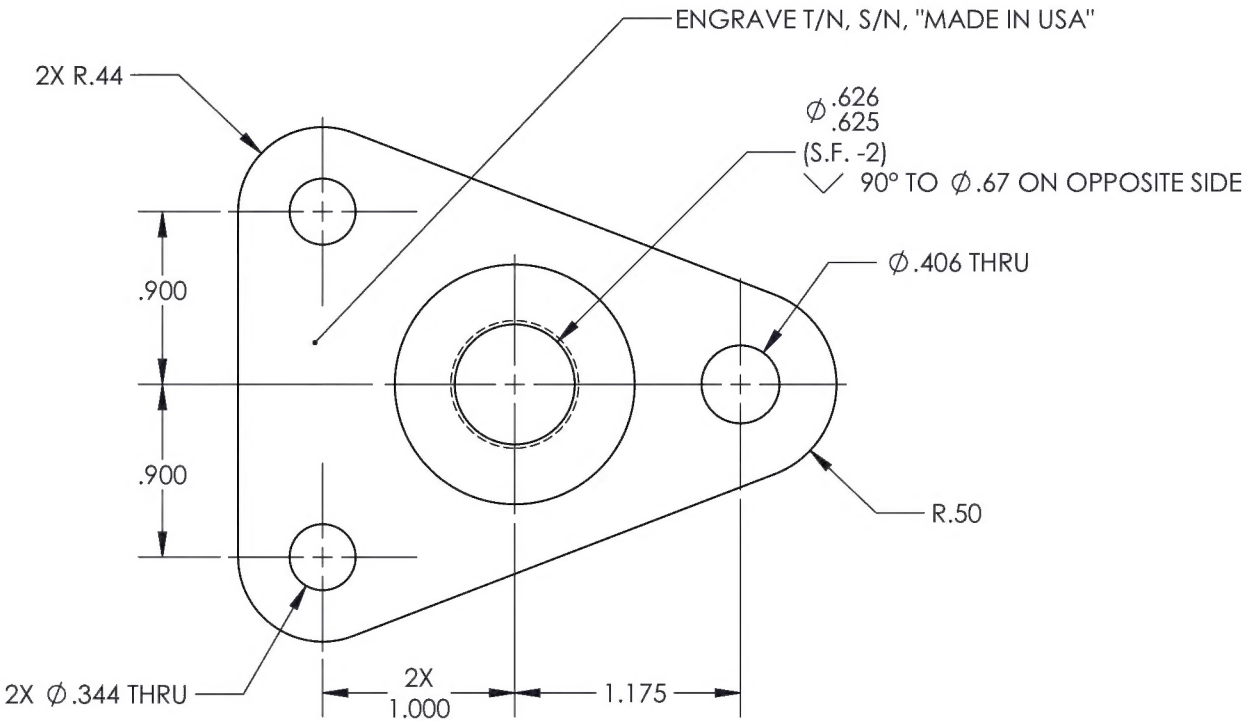
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

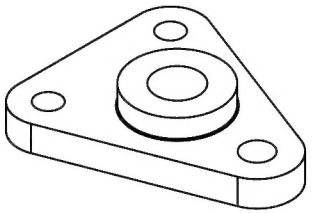
USED ON MODEL: 250 B15

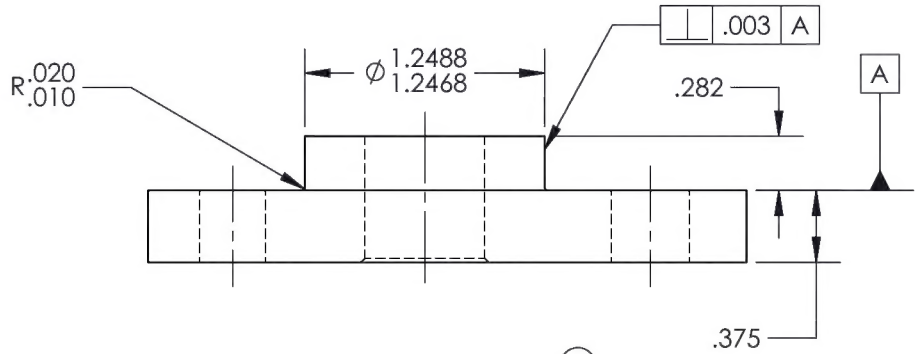
SCALE 1:2 DATE 7/27/2015 SHEET 1 OF 5

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 4140 Q&T/4142 Q&T TO **-1**.	7/27/2015	SM	JAG
3	16-0269	**-1** ADDED ENGRAVE NOTE; CH'D DIM WAS Ø.625 IS Ø.626/.625, WAS 1.000 IS 2X 1.000.	12/6/2016	SM	JAG







(-1)

BASE

DART AEROSPACE

TITLE: ADAPTER-TURNOVER STAND

DWG NO. RB6798316-1 REV. 3

MAT'L	4140/4142
HEAT TREAT	RC 26-32
FINISH	SEE SHT. 1 NOTE 1
SPEC	
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

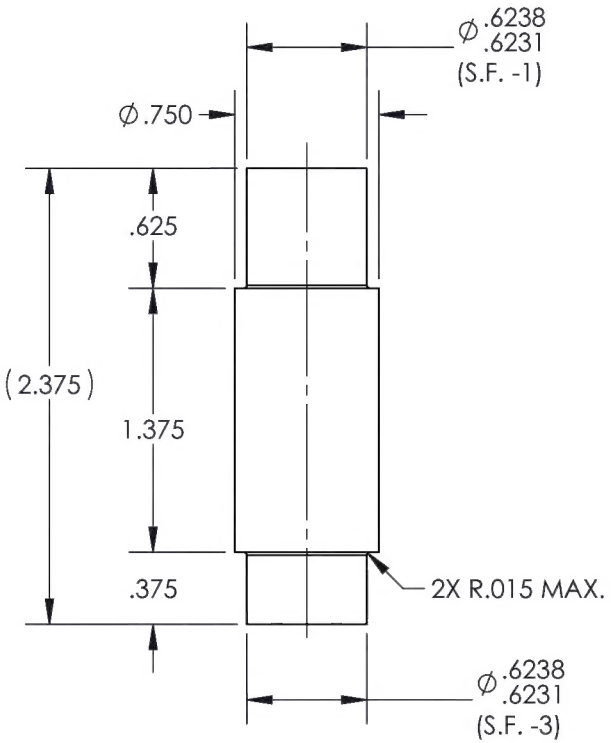
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

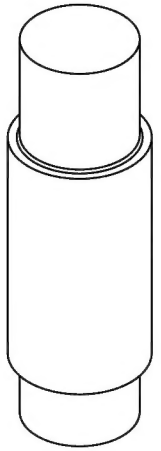
USED ON MODEL: 250 B15

SCALE 1:1 | DATE 7/27/2015 | SHEET 2 OF 5

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 1018/1020 TO **-2**.	7/27/2015	SM	JAG
3	16-0269	**-2** CH'D DIM WAS Ø.625 SLIP FIT WITH -1 IS Ø.6238/.6231 (S.F. -1), WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR.	12/6/2016	SM	JAG





-2

MID POST

DART AEROSPACE

TITLE: ADAPTER-TURNOVER STAND

DWG NO. RB6798316-2 REV. 3

MAT'L	1018/1020 CR
HEAT TREAT	
FINISH	SEE SHT. 1 NOTE 1
SPEC	
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

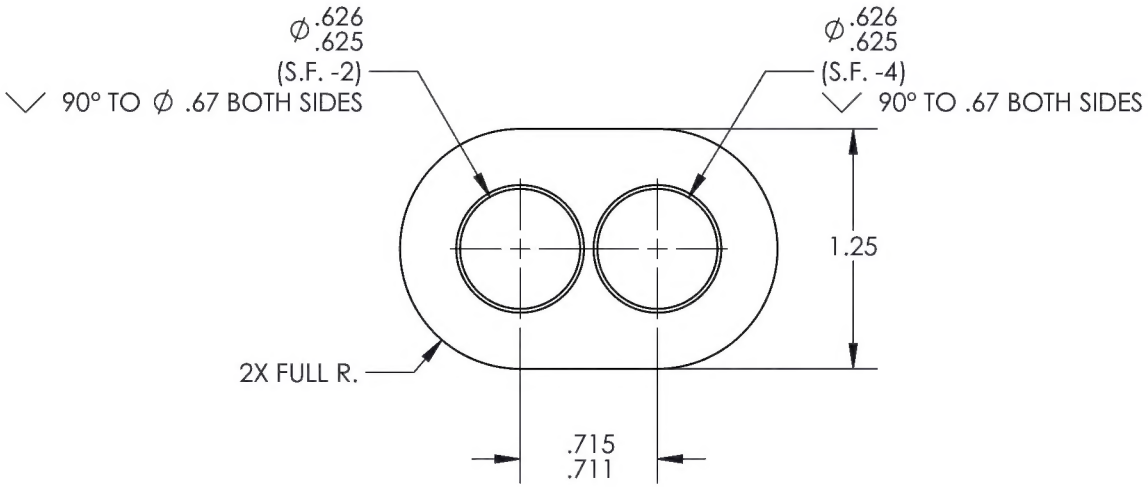
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

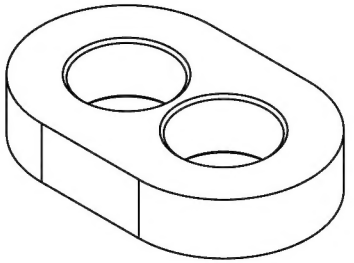
USED ON MODEL: 250 B15

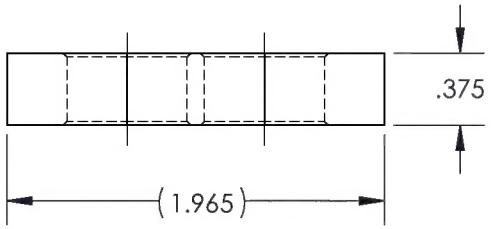
SCALE 1:1 DATE 7/27/2015 SHEET 3 OF 5

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 1018/1020 TO **-3**.	7/27/2015	SM	JAG
3	16-0269	**-3** CH'D DIM WAS Ø.625 SLIP FIT WITH -2 IS Ø.626/.625 (S.F. -2), WAS Ø.625 SLIP FIT WITH -4 IS Ø.626/.625 (S.F. -4); CH'D MATERIAL WAS A36 IS A36/1018/1020 HR.	12/6/2016	SM	JAG







-3

CENTER PLATE

DART AEROSPACE

TITLE: ADAPTER-TURNOVER STAND

DWG NO. RB6798316-3 REV. 3

MAT'L	A36/1018/1020 HR
HEAT TREAT	
FINISH	SEE SHT. 1 NOTE 1
SPEC	
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

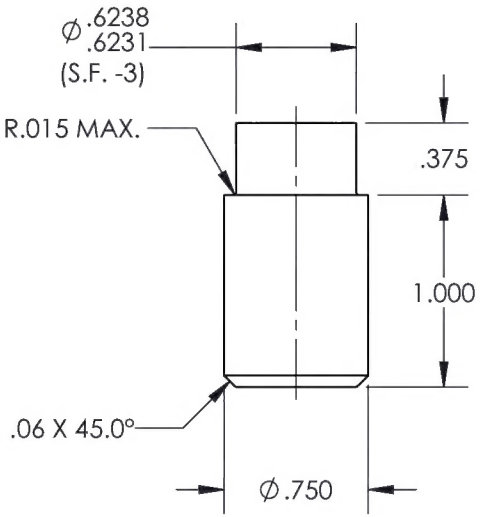
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

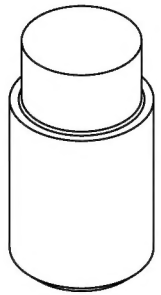
USED ON MODEL: 250 B15

SCALE 1:1 DATE 7/27/2015 SHEET 4 OF 5

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0186	UPDATE TO NEW DRAFTING STANDARDS. ADD MATERIAL OPTION 4140 Q&T/4142 Q&T TO **-4**.	7/27/2015	SM	JAG
3	16-0269	**-4** CH'D DIM WAS Ø.625 SLIP FIT WITH -3 IS Ø.6238/.6231 (S.F. -3); CH'D MATERIAL WAS 4140 Q&T/4142 Q&T IS 4140/4142; ADDED HEAT TREAT.	12/6/2016	SM	JAG





(-4)

END POST

DART AEROSPACE

TITLE: ADAPTER-TURNOVER STAND

DWG NO. RB6798316-4 REV. 3

MAT'L	4140/4142
HEAT TREAT	RC 28-34
FINISH	SEE SHT. 1 NOTE 1
SPEC	
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL: 250 B15

SCALE 1:1 DATE 7/27/2015 SHEET 5 OF 5